

Date: Monday, 3/5/2007 4:23:02 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REDUCER TEE ASSY
Job Number : 31018	
Estimate Number : 12762	
P.O. Number : N/A	Part Number : 41232 200 004 001
This Issue : 3/5/2007 S.O. No. : N/A	Drawing Number : 41232-200-004 REV IR
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : IR
Previous Run : N/A	Material : N/A
Type : MACHINED PARTS	Due Date : 3/12/2007
Written By : <u>[Signature]</u>	Qty: . 12 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.03.06	
Comment : Est Rev. New Issue 07-03-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	AN8154J	union
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
union
Batch: M102929

[Signature] 07.03.19 (12)

2.0	AS1035J080812	TEE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
TEE
Batch: M103237

[Signature] 07.03.20 (12)

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
1-Turn AN815-4J as per Dwg 41232-200-004
2-Deburr as Required.

[Signature] 07.03.19 (12)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1-Drill as per Dwg 41232-200-004
2-Deburr

[Signature] 07.03.20 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/03/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REDUCER TEE ASSY

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Part Number: 41232 200 004 001

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

67.03.20 (12)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

67.03.20 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg 41232-200-004

A/R SS Rod

Batch:

M102576



07/03/21 (12)

8.0

QC5/9

WELD INSPECTION



Comment: 1-WELD INSPECTION

PD

07-03-21 (12)

2-Pressure test as per Dwg 41232-200-004

3-Passivate Finish.

Pickling solution
Passivating solution

Soudotec

M102991

#623745

M102991

#624809

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6/3/26

7/03/25

(12) SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/27

Job Completion



u 7/03/27

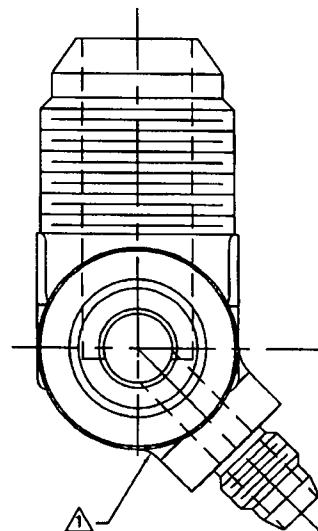
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


QA: N/C Closed: _____ Date: _____

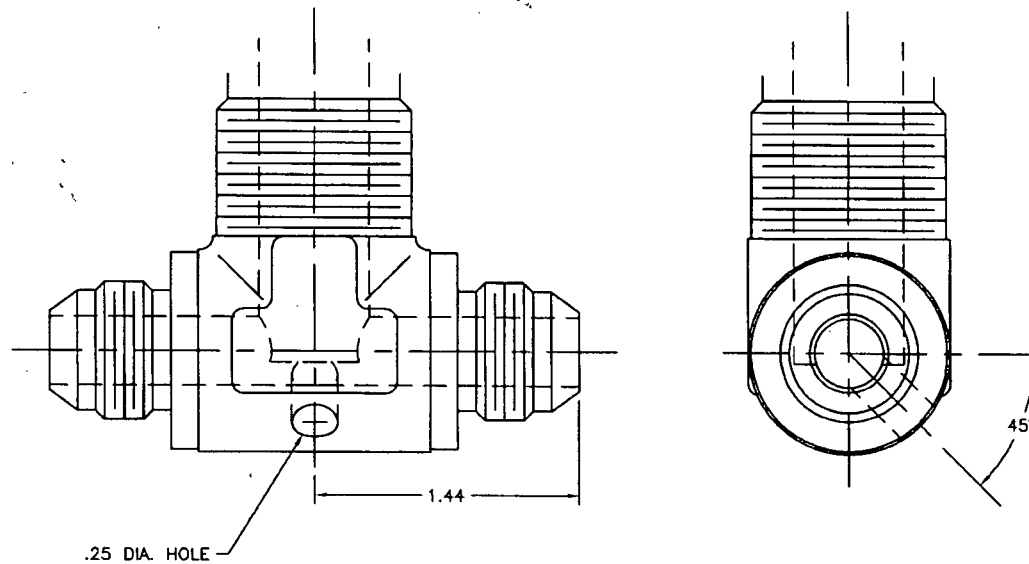
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

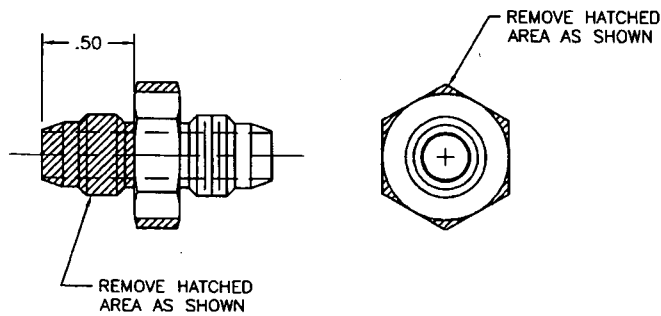


-001 REDUCER TEE ASSY

				1	-005	UNION	MAKE FROM AN815-4J UNION		
				1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-12C		
				1	-001	REDUCER TEE ASSY			
				-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC
NO. REQ'D PER ASSY					LIST OF MATERIAL				
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					DRAFTSMAN D. NELSON 5/24/02 CHECKER D. MURPHY 5/24/02 STRESS PROL ENGR.				
					TITLE REDUCER TEE ASSY				
					DWG. SIZE C SCALE 2:1				
-001 2 41232-000-001 NEXT ASSEMBLY					HEAT TREAT FINISH 				
DWH NO. 41232-200-004 REV. SHT 1 OF 2					REV. IR				



-003 REDUCER TEE



-005 FITTING

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31018

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Era Aviation, Inc.

TITLE REDUCER TEE ASSY	SIZE C	DWG. NO. 41232-200-004 SHT 2 OF 2	REV. IR
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41232-200-004-001

Handwritten signature: *AA*